

Date: Tuesday, 31/03/2009 1:04:40 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INSIDE WASHER
Job Number : 46744	
Estimate Number : 11152	
P.O. Number :	Part Number : D32331 <i>FR</i>
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D3233 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 45267	Material :
Written By :	Due Date : 07/04/2009 Qty: 20 Um: Each
Checked & Approved By : <i>JUD 09-03-31</i>	
Comment : Est. B 05.03.31 Added Powder Coat KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1020TR2000W500	1020-1025 round tubing 2.00 x .500w
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Comment: Qty.: 0.0656 f(s)/Unit Total : 1.3125 f(s)

1020-1025 Round Tube

Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall

(M1020TR2.000W.500)

Identify for D3233-1

Batch: *M102210*

.058' f(s) 1.23' total

09.05.08

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA517 and Dwg D3233

Deburr

09.05.08

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09.05.08

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09.05.08

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M102091

START TIME:

4:30

OVEN TEMPERATURE:

320°

FINISH TIME:

9:00

09.05.13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSIDE WASHER

Job Number: 46744

Part Number: D32331

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-13

(22)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA025A

09.05.14

(22)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion



MF 09-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

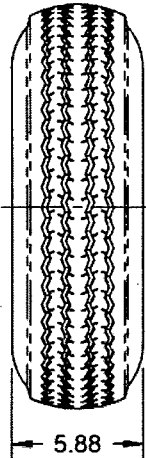
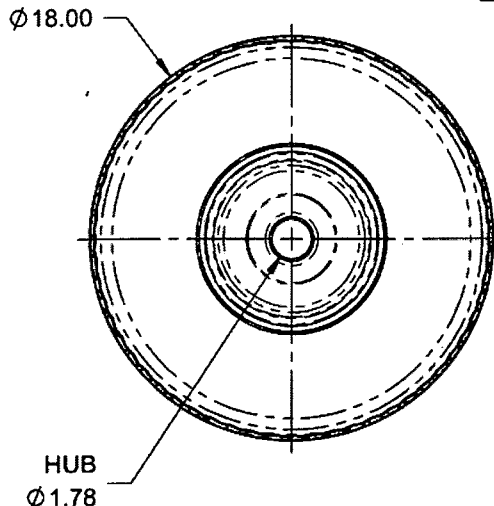
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

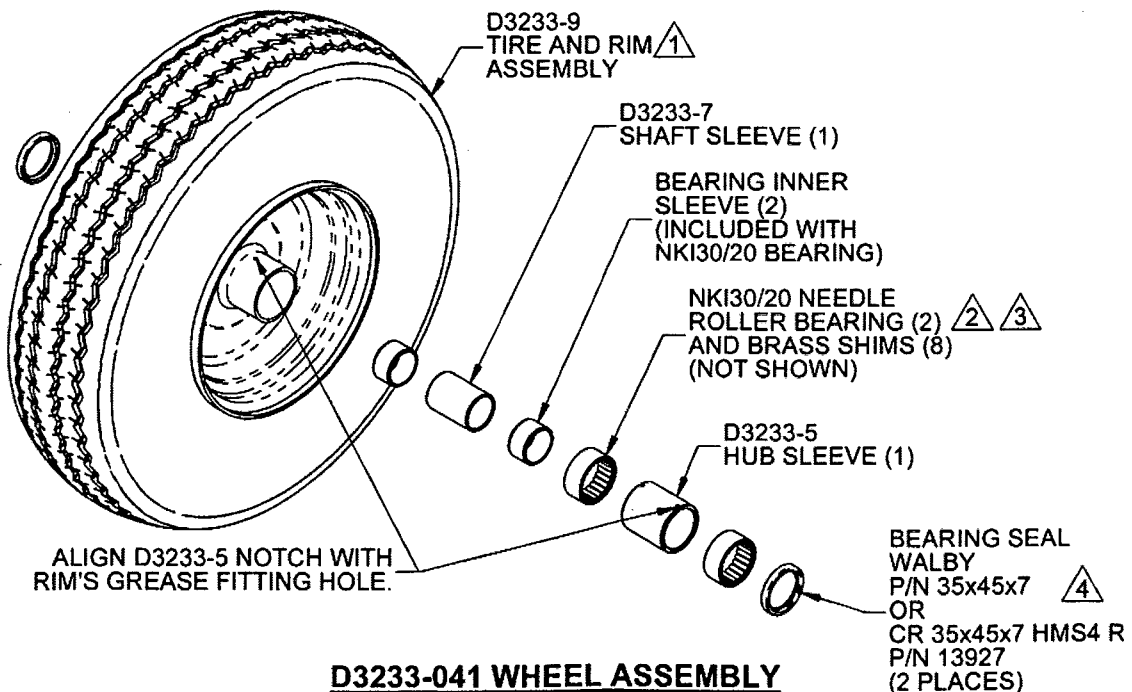
DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

**RELEASED**
[Signature]
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8	910 LBS	90 PSI*
RIM: 5.70 x 8.0	(RANGE C)	

* MANUFACTURER'S RECOMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.

**D3233-041 WHEEL ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

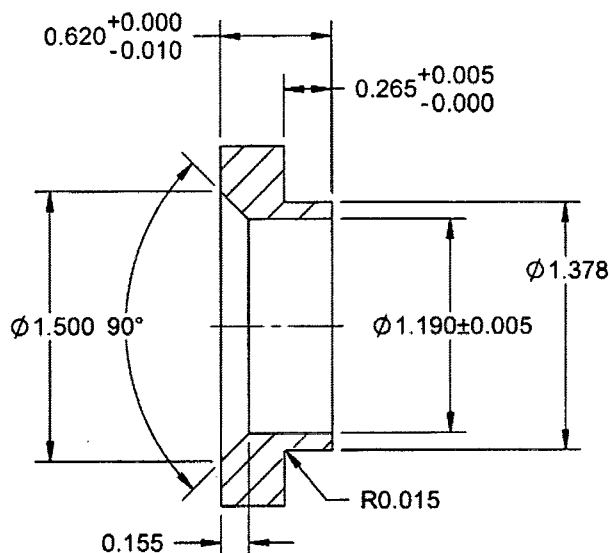
NO. *[Handwritten: 117]*

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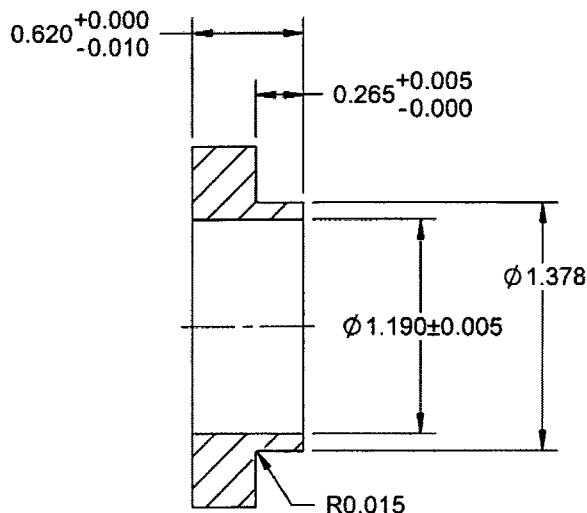
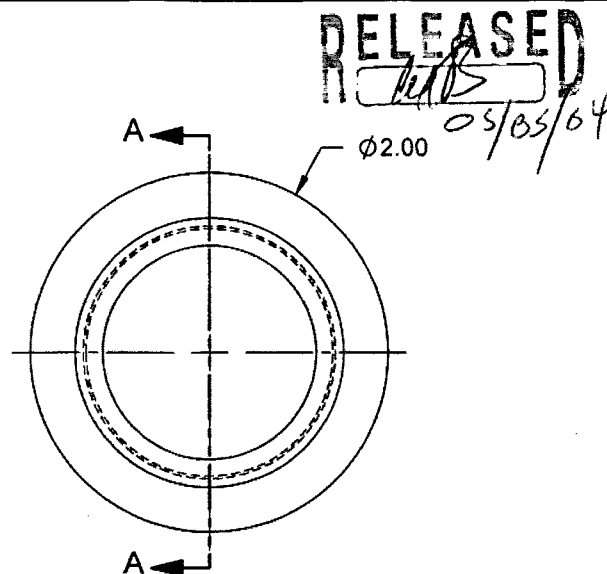


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



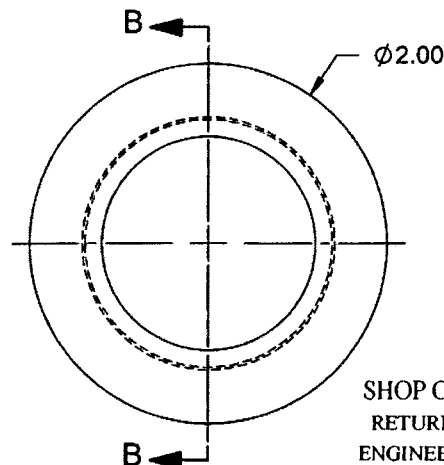
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



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NO. *216744*

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

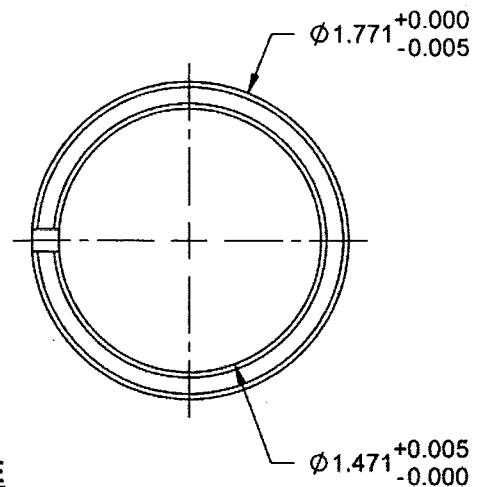
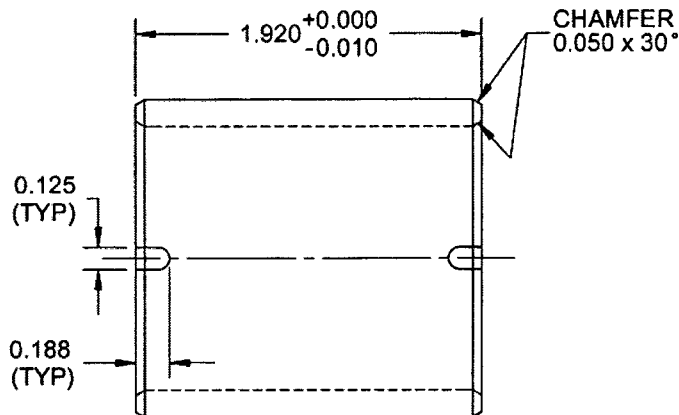
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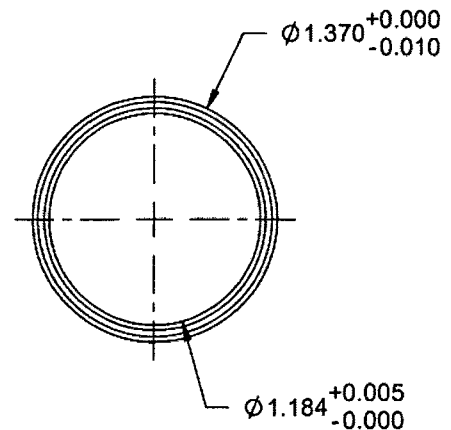
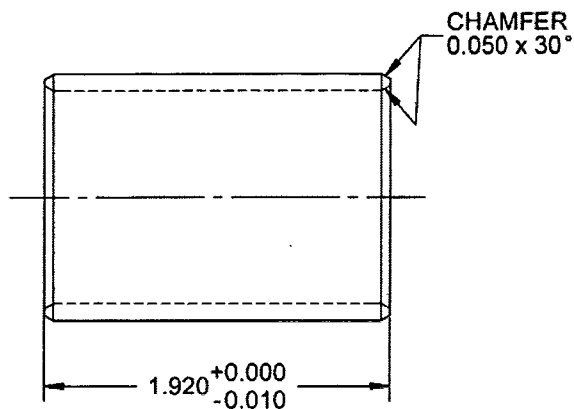


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

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[Signature]
05/05/09



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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NO. *40744*

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